Work Order ID 53774

November 18, 2009 8:42:00 AM

Item ID: D2893-1
Revision ID: B
Item Name: 2.75 Support
Start Date: 18/11/2009 **Start Qty:** 20.00
Required Date: 30/11/2009 **Req'd Qty:** 20.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** DK **Date:** 09-11-16 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D2893 / Rev B									
100	HAAS CNC VERTICAL MACHINING #1	0.00				20	0		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA081 Tumble & Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				20	0		
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				20	0		
QC	**Memo**	0.00							
Quality Control									

09.12.14
Y.A 09/12/15
Y.A 09/12/15
09.12.17
09/12/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 53774

November 18, 2009 8:42:00 AM

Item ID: D2893-1
Revision ID: B
Item Name: 2.75 Support
Start Date: 18/11/2009 **Start Qty:** 20.00
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Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M113170 **Memo** Mask Inside Bore for Primming☐START TIME: 1:30pm ☐OVEN TEMPERATURE: 2:00pm ☐FINISH TIME: 40092	0.00 0.00 0.00	10101104			X20	0		
140 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				20			
150 SprayPaint Spray Painting	SprayPaint **Memo** Prime inside surface as per Dwg D2893 and QSI 005 4.3	0.00 0.00				10	03	02	20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 53774

November 18, 2009 8:42:00 AM

Item ID: D2893-1
Revision ID: B
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Start Date: 18/11/2009 **Start Qty:** 20.00
Required Date: 30/11/2009 **Req'd Qty:** 20.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC14- Inspect Spray Paint	0.00							
QC	**Memo**	0.00				RT	10	03	03 (x20)
Quality Control									
170	Identify as per dwg & Stock Location: LG	0.00							
Packaging	**Memo**	0.00				M	10	03	03 (20)
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control							10/03/03		

MF
10-3-3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

November 18, 2009 8:42:07 AM

Work Order ID: 53774

Parent Item: D2893-1RevB

Parent Item Name: 2.75 Support

Comments:

Start Date: 18/11/2009 **Required Date:** 30/11/2009

Start Qty: 20.00 **Required Qty:** 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
DSK078RevA		Manufactured	No			100	Each	15.0000	10.0000			

D2893-1 TURNING DETAIL

Warehouse Location	Loc Qty	Loc Code			
Main Warehouse					
MAT	15				
47395	5				
51879	10				
53591	10		+0	B.A	09/12/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	53774
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

[X] First Article [ ] Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.990	2.987	2.988	2.988	2.990
AB	0.440	0.460		0.455	0.445	0.446	0.450	0.453
AC	0.125	0.160		0.130	0.127	0.127	0.130	0.129
AD	0.040	0.060		0.055	0.055	0.055	0.055	0.055
AE	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AF	0.125	0.160		0.136	0.136	0.136	0.136	0.136
AG	0.140	0.160		0.153	0.151	0.149	0.154	0.153
AH	1.360	1.400		1.379	1.382	1.380	1.380	1.378
AI	0.040	0.060		0.053	0.049	0.044	0.050	0.053
AJ	1.190	1.230		1.225	1.230	1.222	1.228	1.226
AK	0.010	0.020		0.011	0.011	0.011	0.011	0.011
AL	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.524	2.527	2.525	2.526	2.526
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR								
AS								
AT								
			Accept/Reject					

Measured by:	B. A	**Date:**	09/12/15
Audited by:		**Date:**	09/12/15
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD	Work Order:	53774
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

[X] First Article [ ] Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#6	#7	#8	#9	#10
HAAS Section								
AA	2.985	3.005		2.986	2.991	2.990	2.990	2.990
AB	0.440	0.460		0.446	.450	.450	.450	.450
AC	0.125	0.160		0.128	.135	.140	.140	.40
AD	0.040	0.060		0.055	.050	.050	.080	.050
AE	0.188	0.193		0.190	.187	.187	.187	.187
AF	0.125	0.160		0.136	.146	.150	.150	.150
AG	0.140	0.160		0.152	.150	.150	.150	.150
AH	1.360	1.400		1.382	1.378	1.378	1.376	1.376
AI	0.040	0.060		0.051	.050	.050	.050	.050
AJ	1.190	1.230		1.229	1.225	1.221	1.218	1.215
AK	0.010	0.020		0.011	.011	.011	.011	.011
AL	0.053	0.073		0.063	.063	.063	.063	.063
AM	0.240	0.260		0.250	.250	.250	.250	.250
AN	2.518	2.538		2.527	2.527	2.527	2.527	2.527
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		0.261	.261	.261	.261	.261
AQ	0.053	0.073		0.063	.063	.063	.063	.063
AR								
AS								
AT								
			Accept/Reject					

Measured by:	H.A	**Date:**	09/12/16
Audited by:		**Date:**	09/12/30
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order:	53774
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

[X] First Article [ ] Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	2.985	3.005		2.990	2.990	2.990	2.990	2.990
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.140	.140	.140	.140	.140
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.150	.150	.150	.150	.150
AG	0.140	0.160		.150	.150	.150	.150	.150
AH	1.360	1.400		1.378	1.378	1.378	1.378	1.378
AI	0.040	0.060		.050	.050	.050	.050	.050
AJ	1.190	1.230		1.220	1.220	1.220	1.220	1.220
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.527	2.527	2.527	2.527	2.527
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
			Accept/Reject					

Measured by:		Date:	09.12.18
Audited by:		Date:	09/12/30
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD	Work Order:	53774
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893 **Rev:** B		Page 1 of 1

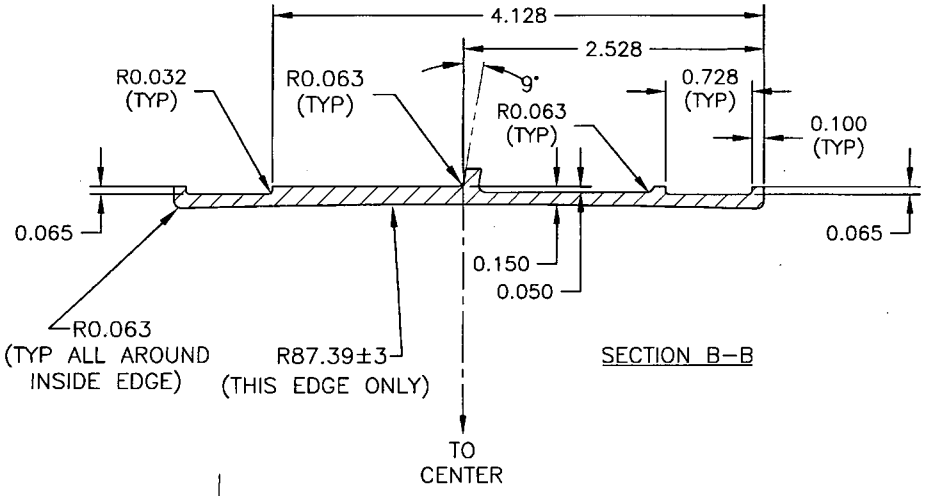
FIRST ARTICLE INSPECTION DIMENSION SHEET

[X] First Article [ ] Prototype

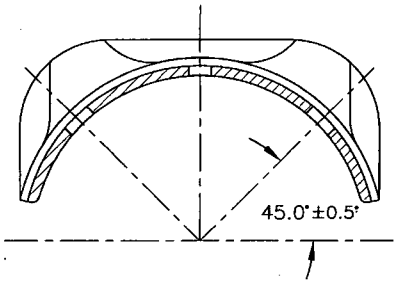
				Record Actual Dimensions				
Dim	**Min**	**Max**	**Go/No Go Gauge**	16	#17	#18	#19	#20
HAAS Section								
AA	2.985	3.005		2.990	2.990	2.990	2.990	2.990
AB	0.440	0.460		.450	.450	.050	.450	.450
AC	0.125	0.160		.140	.140	.140	.140	.140
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.150	.150	.150	.150	.150
AG	0.140	0.160		.150	.150	.150	.150	.150
AH	1.360	1.400		1.370	1.370	1.370	1.370	1.370
AI	0.040	0.060		.050	.050	.050	.050	.050
AJ	1.190	1.230		1.220	1.22	1.220	1.220	1.220
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.527	2.527	2.527	2.527	2.527
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.250	.250	.250	.250	.250
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
			Accept/Reject					

Measured by:		**Date:**	09.12.18
Audited by:		**Date:**	09/12/18
Prototype Approval:		**Date:**	

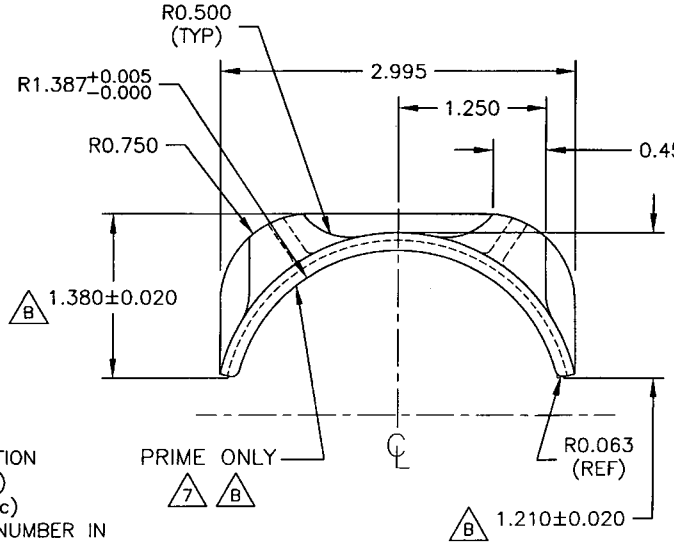
Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

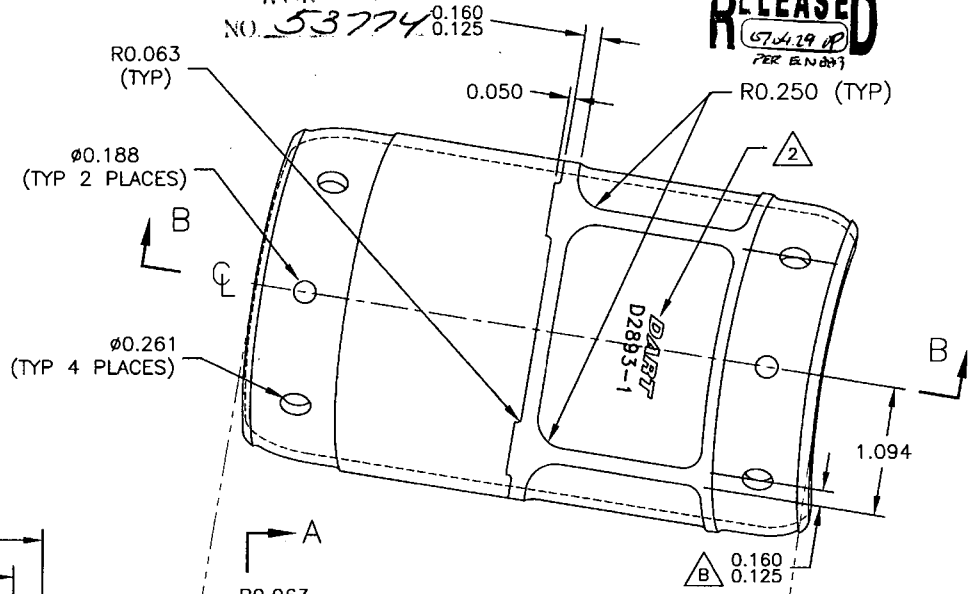


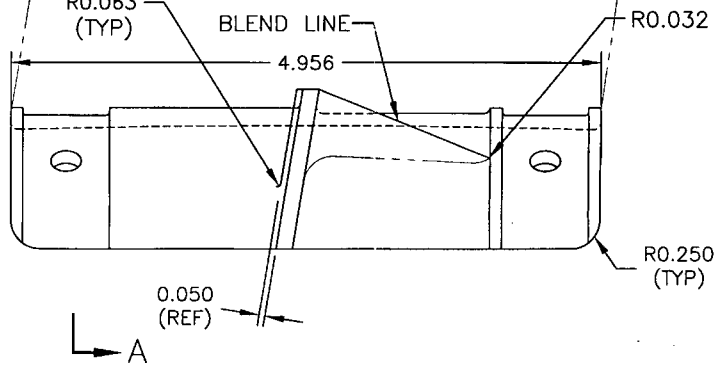
SECTION B–B



SECTION A–A
TOOLING HOLE DETAIL







RELEASED
07.04.29 GP
PER ECN #93

NO. 53774

D2893–1

1) MATERIAL: 17–4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010–0.020 DEEP
3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
4) PART IS SYMMETRIC ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE
A	01.01.10	NEW ISSUE

DESIGN GP	DRAWN BY PH	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2893	REV. B SHEET 1 OF 1
DATE 07.03.16		TITLE ø2.750 SUPPORT	SCALE 1:1